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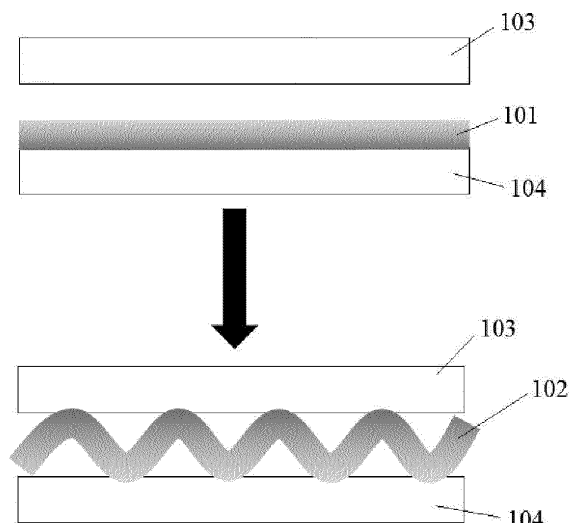
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(54) **TAPE**

(57) A tape for fixing an electrode assembly and a method of manufacturing a battery are provided. The tape for fixing an electrode assembly can effectively fix an electrode assembly in a can by realizing a 3D shape

by means of an electrolyte. Thus, the tape can be useful in preventing the electrode assembly from moving and rotating inside a can by external vibration or impact and also preventing damage of welded regions of a tab or disconnection of inner circuits.

Fig. 1.



Description

CROSS-REFERENCE TO RELATED APPLICATION

[0001] This application claims priority to and the benefit of Korean Patent Application Nos. 10-2011-0008160, filed on January 27, 2011 and 10-2012-0008487 filed on January 27, 2012, the disclosure of which is incorporated herein by reference in its entirety.

BACKGROUND

1. Field of the Invention

[0002] The present application relates to a tape for fixing an electrode assembly and a method of manufacturing a battery.

2. Discussion of Related Art

[0003] A secondary cell can convert electric energy into chemical energy, store the chemical energy, and generate electricity as necessary. A lead storage battery, a nickel-cadmium (NiCd) battery, a nickel-hydrogen (NiMH) storage battery, a lithium ion (Li-ion) battery and a Li-ion polymer battery are known as secondary cells.

[0004] A battery may be manufactured, for example, by receiving an electrode assembly inside a can and injecting an electrolyte. In general, the electrode assembly is small in size compared to the can, and thus a gap is formed between the electrode assembly and an inner wall of the can.

[0005] In this case, the electrode assembly received in the can may move or rotate to some degree inside the can due to external vibration or impact. In this case, inner circuits may be disconnected due to damage of a welded region of a tab, thereby causing undetected power outage.

SUMMARY OF THE INVENTION

[0006] The present application is directed to providing a tape for fixing an electrode assembly and a method of manufacturing a battery.

[0007] One aspect of the present application provides a tape for fixing an electrode assembly. The tape according to one exemplary embodiment may include a substrate layer and a pressure-sensitive adhesive layer formed on at least one surface of the substrate layer. In this case, the substrate layer may be a substrate layer having a property of deforming, for example, swelling in a longitudinal direction, when coming in contact with an electrolyte.

[0008] Throughout this specification, the term "tape for fixing an electrode assembly" may mean a tape that functions to fill a gap between an electrode assembly and a can in which the assembly is received, and fix the electrode assembly inside the can, as necessary. According to one exemplary embodiment, the tape for fixing an electrode assembly may be a tape that may realize a three-dimensional (3D) shape that fills the gap by means of mutual balance between a fixing force of a pressure-sensitive adhesive layer and a force generated as a substrate layer swells, for example, when the substrate layer comes in contact with a liquid-phase electrolyte in a state in which the tape is attached via the pressure-sensitive adhesive layer to the electrode assembly having the gap formed therein. According to one exemplary embodiment, the tape may be, for example, a sealing tape for an electrode assembly, and may be used to prevent disassembly of the electrode assembly and also fix the electrode assembly inside a can of a battery.

[0009] FIG. 1 is a schematic diagram showing the tape for fixing an electrode assembly filling a gap by realizing a 3D shape in the gap.

[0010] As shown in FIG. 1, the tape 101 is attached via a pressure-sensitive adhesive layer to the electrode assembly 104 having a gap formed therein. When the tape 101 is attached to an electrode assembly 104, an electrolyte is introduced into the gap, and a substrate layer swells, for example, in a longitudinal direction when the electrolyte comes in contact with the substrate layer of the tape 101 for fixing an electrode assembly. The substrate layer swells in a state where the tape 101 is fixed to the electrode assembly 104 via the pressure-sensitive adhesive layer. Therefore, the tape 102 is realized in a 3D shape, and a gap is filled by the 3D shape. As necessary, the electrode assembly 104 and a can 103 which have the gap formed therebetween may be fixed to each other.

[0011] As such, a size of the 3D shape realized by the tape for fixing an electrode assembly, that is, a width of the gap may be, for example, in a range of 0.001 mm to 2.0 mm, 0.001 mm to 1.0 mm or 0.01 mm to 0.5 mm. However, the size of the 3D shape may be varied according to specific kinds of the gap to which the tape for fixing an electrode assembly is applied, but the present application is not particularly limited thereto. The size of the 3D shape according to the size of the gap to which the tape for fixing an electrode assembly is applied may be, for example, controlled by

regulating a strain of the substrate layer or a peel strength of the pressure-sensitive adhesive layer, as will be described later.

[0012] The substrate layer included in the tape may be, for example, a substrate layer having a property of deforming in a longitudinal direction when the substrate layer comes in contact with an electrolyte that is present in a liquid phase. For example, when the substrate layer comes in contact with the electrolyte, the substrate layer may be a substrate layer having a property of swelling in a longitudinal direction.

[0013] Throughout this specification, the term "longitudinal direction" used herein may refer to a vertical direction to the direction of thickness (for example, a direction indicated by an arrow shown in FIG 2) of the substrate layer when the substrate layer is maintained in a flat level. In addition, the term "vertical" or "horizontal" may mean substantially vertical or horizontal within a range in which desired effects are not damaged, and for example, may include errors of $\pm 10^\circ$, $\pm 5^\circ$, or $\pm 3^\circ$.

[0014] The substrate layer, which may be deformed, for example, swelled in any direction including a width, length, or diagonal direction, may be used without limitation as long as the substrate layer has a property of deforming, for example, swelling in a longitudinal direction.

[0015] According to one exemplary embodiment, the substrate layer may have a strain of at 10% or more in a longitudinal direction according to the following Equation 1.

[0016]

Equation 1

$$\text{Strain of Substrate layer in Longitudinal direction} = (L_2 - L_1) / L_1 \times 100$$

[0017] In Equation 1, L_1 represents an initial length of the substrate layer before the substrate layer comes in contact with a electrolyte; and L_2 represents a length of the substrate layer that is measured after the substrate layer contacts the electrolyte at room temperature or 60 °C for 24 hours.

[0018] For the calculation according to Equation 1, specific kinds of the electrolyte with which the substrate layer comes in contact may be electrolytes used according to the kinds of batteries to which the tape is applied. Thus, specific kinds of the electrolyte are not particularly limited. According to one exemplary embodiment, the electrolyte may be a liquid-phase electrolyte solution, for example, a carbonate-based electrolyte solution. As such, the term "electrolyte" may refer to an ion conduction medium used for, for example, a battery.

[0019] In addition, the term "room temperature" in this specification may mean a naturally occurring temperature, which is not a heated or cooled, and for example, may refer to approximately 10 °C to approximately 30 °C, approximately 20 °C to approximately 30 °C, or approximately 25 °C.

[0020] A strain of the substrate layer in a longitudinal direction may be deformed according to a size of a 3D shape to be realized, and for example, may be 30% or more, 40% or more, 50% or more, 60% or more, 70% or more, 80% or more or 90% or more. An upper limit of the strain of the substrate layer in the longitudinal direction is not specifically limited. In other words, the higher a value of the strain is, the larger the 3D shape may be realized, and thus the strain may be, for example, controlled according to the size of a desired 3D shape. For example, an upper limit of the strain of the substrate layer may be approximately 500%.

[0021] In Equation 1, L_1 and L_2 represent lengths of the substrate layer before and after the substrate layer comes in contact with the electrolyte. The length is measured in a predetermined direction with respect to the substrate layer. As long as the direction is equally applied when L_1 and L_2 are measured, a specific direction of measuring the length is not specifically limited.

[0022] For example, when the substrate layer has a tetragonal sheet shape, the length of the substrate layer may be a length in a width, length or diagonal direction, or may be a length in any direction on a plane. However, the direction of measuring the length may be equally applied when L_1 and L_2 are measured, and thus, for example, the width length of the substrate layer is also used as L_2 when the width length of the substrate layer is used as L_1 .

[0023] The shape of the substrate layer is not specifically limited, but for example, may be a film or a sheet shape. In addition, the substrate layer with the film or sheet shape may have shapes such as a rectangular, circular, triangular, or amorphous shape.

[0024] A material for the substrate layer may include any material that can have the above-described strain. According to one exemplary embodiment, the substrate layer may be a polymer film or sheet, and may be the film or sheet manufactured to have the above-described deformation property, for example, an swelling property, when the substrate layer comes in contact with a electrolyte by the conditions of elongation or shrinking in a manufacturing process.

[0025] According to one exemplary embodiment, the substrate layer including a urethane bond, an ester bond, or an ether bond, or a cellulose ester compound may be used as the substrate layer.

[0026] The above-described substrate layer may include, for example, an acrylate-based substrate layer, a urethane-based substrate layer, an epoxy-based substrate layer, or a cellulose-based substrate layer.

[0027] According to one exemplary embodiment, a cast layer of an active energy ray-curable composition may be used as the acrylate-based, the urethane-based, or the epoxy-based substrate layer.

[0028] The term "cast layer" used herein may refer to a substrate layer formed through curing a coating layer after coating a curable composition using a casting method.

[0029] In addition, the term "active energy ray-curable composition" as described above may refer to a type of a composition cured irradiation with active energy rays. A scope of the active energy rays as described above may also include a particle beam, such as an alpha-particle beam, a proton beam, a neutron beam, and an electron beam as well as microwaves, infrared rays (IR), UV rays (UV), X-ray, and a gamma-ray.

[0030] The composition may include, for example, an active energy ray-curable acrylate compound and a radical-polymerizable diluent.

[0031] The active energy ray-curable acrylate compound as described above may include, for example, a urethane acrylate that is known as a photocurable oligomer in the art

[0032] The urethane acrylate may include, for example, a reactant of a mixture including a (meth) acrylate having a hydroxyl group and a polyisocyanate compound. As such, the polyisocyanate compound may be a compound having at least two isocyanate groups; for example, an aliphatic, cycloaliphatic, or aromatic polyisocyanate; and specifically, for example, 2, 4-tolylene diisocyanate, 2, 6-tolylene diisocyanate, 1, 3-xylylene diisocyanate, 1, 4-xylylene diisocyanate, diphenylmethane-4, 4'-diisocyanate isophorone diisocyanate, and the like. In addition, the (meth) acrylate having the hydroxyl group may include a hydroxyalkyl (meth) acrylate, such as 2-hydroxyethyl (meth) acrylate, 2-hydroxypropyl (meth) acrylate, 4-hydroxybutyl (meth) acrylate, 6-hydroxyhexyl (meth) acrylate, or 8-hydroxyoctyl (meth) acrylate, but the present application is not limited thereto.

[0033] The urethane acrylate may include a reactant including a (meth) acrylate having a hydroxyl group and a urethane prepolymer having an isocyanate group at the end thereof, for example, a reactant of the mixture including a polyisocyanate and an ester polyol. The ester polyol may include, for example, a polyol and/or an ether polyol; and a reactant that is esterified with an acid component, such as a dibasic acid or an anhydride thereof. The polyol may include, for example, ethylene glycol, propylene glycol, cyclohexane dimethanol, 3-methyl-1, 5-pentanediol, and the like, and the ether polyol may include, for example, a polyalkylene glycol, such as polyethylene glycol, polypropylene glycol, or polytetramethylene glycol, a diol of a block or a random polymer, such as a polyethylene polypropoxy block polymer diol; and the acid component may include, for example, a dibasic acid or an anhydride thereof, such as adipic acid, succinic acid, phthalic acid, tetrahydrophthalic acid, hexahydrophthalic acid, and terephthalic acid, but the present application is not limited thereto. Also, the (meth) acrylate having the hydroxyl group and the polyisocyanate may include the compounds described above.

[0034] Also, the urethane acrylate may be a reactant of the mixture including a (meth) acrylate having a hydroxyl group and a urethane prepolymer having an isocyanate at the end thereof, for example, a reactant of the mixture including a polyisocyanate and an ether polyol.

[0035] Also, the active energy ray-curable acrylate compound may include an epoxy acrylate, a polyester acrylate, a polyether acrylate, and the like.

[0036] The polyester acrylate may include, for example, a dehydration condensation reactant of the mixture including a (meth) acrylic acid and an ester polyol. In this case, the above-described compounds may be used as an ester polyol, which can be used.

[0037] In addition, the polyether acrylate may include, for example, a polyalkylene glycol di(meth) acrylate, such as polyethylene glycol di(meth) acrylate, polypropylene glycol di(meth) acrylate, or polytetramethylene glycol di(meth) acrylate, and the epoxy acrylate may be an additive reactant of the mixture including a (meth) acrylic acid and an epoxy resin. In this case, a type of the epoxy resin may include a general aromatic or aliphatic epoxy resin that is known in the art, but the present application is not limited thereto.

[0038] The radical-polymerizable diluent included in the composition may include, for example, a monomer having a functional group that can participate in radical polymerization by irradiation with active energy rays.

[0039] The monomer may be a (meth) acrylic acid ester monomer, and may be, for example, at least one selected from the group consisting of an alkyl (meth) acrylate; a (meth) acrylate having an alkoxy group, a (meth) acrylate having an alicyclic group; a (meth) acrylate having an aromatic group; a (meth) acrylate having a heterocycle; and a multifunctional acrylate.

[0040] The alkyl (meth) acrylate may include, for example, an alkyl (meth) acrylate having an alkyl group having 1 to 20 carbon atoms, such as methyl (meth) acrylate, ethyl (meth) acrylate, n-propyl (meth) acrylate, isopropyl (meth) acrylate, n-butyl (meth) acrylate, t-butyl (meth) acrylate, sec-butyl (meth) acrylate, pentyl (meth) acrylate, 2-ethylhexyl (meth) acrylate, 2-ethylbutyl (meth) acrylate, n-octyl (meth) acrylate, isooctyl (meth) acrylate, isononyl (meth) acrylate, lauryl (meth) acrylate, and tetradecyl (meth) acrylate; the (meth) acrylate having the alkoxy group may include, for example, 2-(2-ethoxyethoxy) ethyl (meth) acrylate, ethylene glycol phenyl ether (meth) acrylate, polyethylene glycol

(with a degree of polymerization of 2 to 8) phenyl ether (meth) acrylate, ethylene glycol nonyl phenyl ether (meth) acrylate, polyethylene glycol (with a degree of polymerization of 2 to 8) nonyl phenyl ether (meth) acrylate, and the like; the (meth) acrylate having an alicyclic group may include, for example, isobornyl (meth) acrylate, dicyclopentenyl (meth) acrylate, dicyclopentenyl (meth) acrylate, and the like; the (meth) acrylate having the aromatic group may include, for example, phenylhydroxypropyl (meth) acrylate, benzyl (meth) acrylate, and the like; the (meth) acrylate having the heterocycle may include, for example, tetrahydrofurfuryl (meth) acrylate, morpholinyl (meth) acrylate, and the like; the multifunctional acrylate may include, for example, a difunctional acrylate, such as 1, 4-butanediol di(meth) acrylate, 1, 6-hexanediol di(meth) acrylate, neopentylglycol di(meth) acrylate, polyethyleneglycol di(meth) acrylate, neopentylglycol adipate di(meth) acrylate, hydroxyl puivalic acid neopentylglycol di(meth) acrylate, dicyclopentanyl di(meth) acrylate, caprolactone-modified dicyclopentenyl di(meth) acrylate, ethyleneoxide-modified di(meth) acrylate, di(meth) acryloxy ethyl isocyanurate, allylated cyclohexyl di(meth) acrylate, tricyclodecanedimethanol(meth) acrylate, dimethylol dicyclopentane di(meth) acrylate, ethyleneoxide-modified hexahydrophthalic acid di(meth) acrylate, tricyclodecane dimethanol(meth) acrylate, neopentyl glycol-modified trimethylpropane di(meth) acrylate, adamantane di(meth) acrylate, or 9, 9-bis [4-(2-acryloyloxyethoxy) phenyl] fluorene; a trifunctional acrylate, such as trimethylolpropane tri(meth) acrylate, dipentaerythritol tri(meth) acrylate, propionic acid-modified dipentaerythritol tri(meth) acrylate, pentaerythritol tri(meth) acrylate, propyleneoxide-modified trimethylolpropane tri(meth) acrylate, trifunctional urethane (meth) acrylate, or tris(meth) acryloxyethylisocyanurate; a tetrafunctional acrylate, such as diglycerin tetra(meth) acrylate, or pentaerythritol tetra(meth) acrylate; a pentafunctional acrylate, such as propionic acid-modified dipentaerythritol penta(meth) acrylate; and a hexafunctional acrylate, such as depentaerythritol hexa(meth) acrylate, caprolactone-modified dipentaerythritol hexa(meth) acrylate, or urethane (meth) acrylate (for example, a reactant of a trimethylolpropane tri(meth) acrylate and an isocyanate monomer); but the present application is not limited thereto.

[0041] Also, the diluent may include a monomer having a polar functional group, specifically, a hydroxyl group, a carboxyl group, a nitrogen-containing group, or a glycidyl group. The monomer having the hydroxyl group may include 2-hydroxyethyl (meth) acrylate, 2-hydroxypropyl (meth) acrylate, 4-hydroxybutyl (meth) acrylate, 6-hydroxyhexyl (meth) acrylate, 8-hydroxyoctyl (meth) acrylate, 2-hydroxyethylene glycol (meth) acrylate or 2-hydroxypropylene glycol (meth) acrylate, and the like; the monomer having the carboxyl group may include (meth) acrylic acid, 2-(meth) acryloyloxy acetic acid, 3-(meth) acryloyloxy propylic acid, 4-(meth) acryloyloxy butyric acid, an acrylic acid dimer, itaconic acid, maleic acid, or maleic anhydride, and the like; the monomer having the nitrogen-containing group may include (meth) acrylamide, N-vinyl pyrrolidone, N-vinyl caprolactam, and the like; and the monomer having the glycidyl group may include glycidyl (meth) acrylate, and the like; but the present application is not limited thereto.

[0042] The composition may include, for example, 30 parts by weight to 99 parts by weight of the active energy ray-curable acrylate compound and 1 part by weight to 70 parts by weight of the radical-polymerizable diluent. However, the weight percentages and the types of the acrylate compound and the radical-polymerizable diluent may be varied considering a desired strain, for example.

[0043] Unless otherwise indicated, the unit "part by weight" used herein refers to a weight ratio.

[0044] Also, the composition may further include a photoinitiator. The photoinitiator may induce a polymerization reaction of the composition by irradiation with active energy rays.

[0045] The photoinitiator may include, for example, a known photoinitiator such as a benzoin-based, hydroxyketone-based, aminoketone-based, peroxide-based, or phosphine oxide-based photoinitiator.

[0046] The composition may include 0.01 parts by weight to 10 parts by weight or 0.1 parts by weight to 5 parts by weight of the photoinitiator based on the total 100 parts by weight of the acrylate compound and diluent. The content of the photoinitiator may be controlled within the above-described range to induce an effective curing reaction and prevent a degradation of physical properties, and the like, caused by components remaining after curing process.

[0047] The composition may further include at least one additive selected from the group consisting of a pigment and a dye, an epoxy resin, a crosslinking agent, a UV stabilizer, an antioxidant, a toning agent, a reinforcing agent, a filling agent, an antifoaming agent, a surfactant, a photo thickener, and a plasticizer, as necessary.

[0048] The cast layer may be manufactured by coating the composition to a proper thickness using a casting method and curing the composition through polymerization by irradiation with the active energy rays.

[0049] A specific method of casting the composition may be performed in a method such as bar coating, knife coating, roll coating, spray coating, gravure coating, curtain coating, comma coating or lip coating considering a desired thickness, for example, but the present application is not limited thereto.

[0050] In addition, the irradiation with the active energy rays, for example, ultraviolet rays (UV rays), may be performed using a metal halide lamp, a highpressure mercury lamp, a black light lamp, an induction lamp, a xenon lamp, and the like. The conditions for irradiating the active energy rays, for example, a wavelength, light intensity of radiation, and the like, may be selected considering composites of the composition, and the like, but the present application is not specifically limited thereto.

[0051] Also, for example, the substrate layer may include a urethane resin, such as thermoplastic polyurethane (TPU), or a cast layer of the curable urethane composition.

[0052] The curable urethane composition may be a type of a composition that is cured by application of heat, for example, and may include a composition including a polyol and an isocyanate compound.

[0053] The polyol may include, for example, an alkylene glycol, a dialkylene glycol, a benzenediol (for example, catechol, resorcinol, or hydroquinone), a benzenetriol (for example, 1, 2, 3-benzenetriol), a dialcohol amine, a trialcohol amine, arabitol, mannitol, isomalt, glycerol, xylitol, sorbitol, maltitol, erythritol, ribitol, dulcitol, lactitol, threitol, iditol or polyglycitol, and the like. In addition, the isocyanate compound may include, for example, a polyisocyanate as described in a list of the urethane acrylate. The alkylene included in the alkylene glycol or the dialkylene glycol may include, for example, an alkylene having 1 to 20 carbon atoms, 1 to 16 carbon atoms, 1 to 12 carbon atoms, 1 to 8 carbon atoms or 1 to 4 carbon atoms.

[0054] The curable urethane composition may include, for example, a polyol and a polyisocyanate so that an equivalent ratio of a hydroxyl group (OH) of the polyol and an isocyanate group (NCO) of the polyisocyanate can amount to substantially approximately 1:1. However, the equivalent ratio may be changed, for example, considering a desired strain, and the like.

[0055] For example, the cast layer may be manufactured by casting the urethane composition in a method similar to that of the composition, and then curing the urethane composition through application of proper heat to the casted coating layer.

[0056] When a cellulose-based substrate layer is used as the substrate layer, the substrate layer may include a cellulose acetate resin or cellulose alkylate resin. In this case, a substrate layer manufactured by subjecting the mixture including the above resin to an extruding or casting process may be used. The cellulose alkylate may include, for example, cellulose acetate propionate, cellulose acetate butyrate, and the like.

[0057] A method of manufacturing the substrate layer using the resin may include, for example, applying a raw material including the above resin and known additives as necessary in a general film or sheet molding process such as extruding or casting, but also applying a proper treatment in a molding process in order for the substrate layer to exhibit a deformation property, for example, an swelling property, but the present application is not specifically limited thereto.

[0058] When the substrate layer is a sheet or film type, the thickness of the substrate layer may be selected considering a size of a gap to be filled or an probability of realizing a desired 3D shape, and the like, for example, but the present application is not limited thereto.

[0059] The tape may include a pressure-sensitive adhesive layer formed on at least one surface of the substrate layer. For example, the pressure-sensitive adhesive layer may be formed on at least one surface of the substrate layer in a horizontal direction to a longitudinal direction of the above-described substrate layer. FIG 2 is a schematic cross-sectional diagram of the tape, showing a tape 2 including a pressure-sensitive adhesive layer 202, in which the pressure-sensitive adhesive layer 202 is formed at one surface of the substrate layer 201 in a horizontal direction to the longitudinal direction of the substrate layer 201.

[0060] The tape may realize a 3D shape, which protrudes in a vertical direction to the longitudinal direction of the substrate layer by deformation for example, swelling through contacting the tape with an electrolyte in a state in which the tape is fixed by the pressure-sensitive adhesive layer that is formed in a horizontal direction to the longitudinal direction of the substrate layer as described above.

[0061] In order to realize the 3D shape, the pressure-sensitive adhesive layer may be designed to have a proper peel strength. For example, when the peel strength is less than the range for realizing a desired 3D shape, the pressure-sensitive adhesive layer may not properly support stress from deformation of the substrate layer, for example, swelling, and thus the tape may be peeled or the 3D shape may be difficult to realize. On the other hand, when the peel strength is above the range of the peel strength, the pressure-sensitive adhesive layer may excessively inhibit the deformation of the substrate layer and thus the 3D shape may be difficult to realize. The peel strength may be, for example, 100 gf/25 mm or more, 150 gf/25 mm or more, 200 gf/25 mm or more, 300 gf/25 mm or more, 400 gf/25 mm or more, 500 gf/25 mm or more, 600 gf/25 mm or more, 700 gf/25 mm or more, 800 gf/25 mm or more, 900 gf/25 mm or more, 1, 000 gf/25 mm or more, 1, 100 gf/25 mm or more, 1, 200 gf/25 mm or more, 1, 300 gf/25 mm or more, 1, 400 gf/25 mm or more, 1, 500 gf/25 mm or more, 1, 600 gf/25 mm or more, 1, 700 gf/25 mm or more, or 1, 800 gf/25 mm or more. However, the peel strength may be, for example, varied according to a gap to be filled or a size of a 3D shape to be realized, but the present application is not specifically limited thereto. The peel strength may be, for example, a peel strength to a glass plate or one of the subjects forming a gap to be filled. In addition, the peel strength may be measured at room temperature, and may be measured at a peel rate of 5 mm/sec and a peel angle of 180°.

[0062] In addition, the peel strength of the pressure-sensitive adhesive layer may be controlled considering an probability of realizing a desired 3D shape, and an upper limit of the peel strength is not specifically limited.

[0063] Various kinds of pressure-sensitive adhesive layers may be used as the pressure-sensitive adhesive layer as long as they can exhibit the above-described peel strength. For example, an acrylic pressure-sensitive adhesive, a urethane pressure-sensitive adhesive, an epoxy pressure-sensitive adhesive, a silicon pressure-sensitive adhesive, or a rubber-based pressure-sensitive adhesive, and the like, may be used for the pressure-sensitive adhesive layer.

[0064] According to one exemplary embodiment, the pressure-sensitive adhesive layer may be an acrylic pres-

sure-sensitive adhesive layer, and for example, may include an acrylic polymer cross-linked by a multifunctional crosslinking agent.

[0065] The acrylic polymer may include, for example, an acrylic polymer having a weight average molecular weight (M_w) of 400, 000 or more. The weight average molecular weight is a conversion value to standard polystyrene that is measured by gel permeation chromatography (GPC). Unless otherwise indicated, the term "molecular weight" used herein refers to a weight average molecular weight. An upper limit of the molecular weight of the acrylic polymer may be controlled within 2, 500, 000, or less for example, but the present application is not specifically limited thereto.

[0066] The acrylic polymer may include, for example, a copolymerizable monomer having a crosslinkable functional group and a (meth) acrylic acid ester monomer in a polymerized type. In this case, the weight ratio of each monomer may be designed considering a desired peel strength, for example, but the present application is not specifically limited thereto.

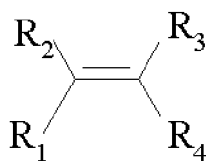
[0067] The (meth) acrylic acid ester monomer included in the polymer may include, for example, an alkyl (meth) acrylate, and may include an alkyl (meth) acrylate having an alkyl group having 1 to 14 carbon atoms considering cohesiveness, a glass transition temperature, or adhesion of the pressure-sensitive adhesive. The monomer may include, for example, one, two or more of methyl (meth) acrylate, ethyl (meth) acrylate, n-propyl (meth) acrylate, isopropyl (meth) acrylate, n-butyl (meth) acrylate, t-butyl (meth) acrylate, sec-butyl (meth) acrylate, pentyl (meth) acrylate, 2-ethylhexyl (meth) acrylate, 2-ethylbutyl (meth) acrylate, n-octyl (meth) acrylate, isooctyl (meth) acrylate, isononyl (meth) acrylate, lauryl (meth) acrylate, tetradecyl (meth) acrylate, and the like, but the present application is not limited thereto.

[0068] The copolymerizable monomer having the crosslinkable functional group may be co-polymerized with the (meth) acrylic acid ester monomer or another monomer included in the polymer, and may give a crosslinking point that can react with a multifunctional crosslinking agent to a main chain of the polymer after copolymerization. The crosslinkable functional group may be a hydroxyl group, a carboxyl group, an isocyanate group, a glycidyl group, an amide group, and the like. In some cases, the crosslinkable functional group may be a photocrosslinkable functional group, such as an acryloyl group, or a methacryloyl group. The photocrosslinkable functional group may be introduced by reacting the crosslinkable functional group provided by the copolymerizable monomer with the compound having a photocrosslinkable functional group. Various copolymerizable monomers, which can be used according to a desired functional group, are known in the field of preparing pressure-sensitive adhesives. An example of the monomer may be a monomer having a hydroxyl group, such as 2-hydroxyethyl (meth) acrylate, 2-hydroxypropyl (meth) acrylate, 4-hydroxybutyl (meth) acrylate, 6-hydroxyhexyl (meth) acrylate, 8-hydroxyoctyl (meth) acrylate, 2-hydroxyethyleneglycol (meth) acrylate, or 2-hydroxypropyleneglycol (meth) acrylate; a monomer having a carboxyl group, such as (meth) acrylic acid, 2-(meth) acryloyloxy acetic acid, 3-(meth) acryloyloxy propionic acid, 4-(meth) acryloyloxy butyric acid, an acrylic acid dimer, itaconic acid, maleic acid, and maleic anhydride; glycidyl (meth) acrylate, (meth) acrylamide, N-vinylpyrrolidone, N-vinylcaprolactam, and the like; but the present application is not limited thereto. One, two or more of the monomers may be included in the polymer.

[0069] The acrylic polymer may further include another functional comonomer in a polymerized type as necessary, and for example, may be a monomer represented by the following Formula 1.

[0070]

Formula 1



[0071] In Formula 1, R_1 to R_3 are each independently hydrogen or an alkyl; and R_4 is a cyano; an alkyl-substituted or unsubstituted phenyl; an acetyl oxy; or COR_5 , wherein R_5 is an alkyl or alkoxyalkyl-substituted or unsubstituted amino or a glycidyloxy.

[0072] The alkyl or alkoxy in definitions of R_1 to R_5 in Formula 1 refers to an alkyl or alkoxy of C_1 to C_8 , and preferably, a methyl, an ethyl, a methoxy, an ethoxy, a propoxy, or a butoxy.

[0073] A specific example of the monomer of Formula 1 may be a vinyl ester of carboxylic acid, such as (meth) acrylonitrile, N-methyl (meth) acrylamide, N-butoxy methyl (meth) acrylamide, styrene, methyl styrene, or vinyl acetate, but the present application is limited thereto.

[0074] The acrylic polymer may be prepared, for example, through solution polymerization, photo polymerization, bulk polymerization, suspension polymerization, emulsion polymerization, and the like.

[0075] Kinds of the multifunctional crosslinking agent that functions to crosslink the acrylic polymer in the pressure-sensitive adhesive layer, and for example, may include an acrylic polymer cross-linked by a multifunctional crosslinking agent.

sitive adhesive layer is not particularly limited, but a proper crosslinking agent may be selected from known crosslinking agents, such as an isocyanate crosslinking agent, an epoxy crosslinking agent, an aziridine crosslinking agent, a metal chelate crosslinking agent, or a photocrosslinking agent, according to a kind of crosslinkable functional group present in the polymer. An example of the isocyanate crosslinking agent may be a diisocyanate, such as tolylene diisocyanate, xylene diisocyanate, diphenylmethane diisocyanate, hexamethylene diisocyanate, isophorone diisocyanate, tetramethylylene diisocyanate, or naphthalene diisocyanate, or a reactant of the diisocyanate and a polyol, and the like. Here, trimethylol propane may be used as the polyol. The epoxy crosslinking agent may include ethylene glycol diglycidylether, triglycidylether, trimethylolpropane triglycidylether, N, N, N', N'-tetraglycidyl ethylenediamine, glycerin diglycidylether, and the like; the aziridine crosslinking agent may include N, N'-toluene-2, 4-bis(1-aziridinecarboxamide), N, N'-diphenylmethane-4, 4'-bis(1-aziridinecarboxamide), triethylene melamine, bisisoprotaloyl-1-(2-methylaziridine), tri-1-aziridinylphosphineoxide, and the like; the metal chelate crosslinking agent may include compounds with a multivalent metal coordinated at a compound, such as acetylacetone or ethyl acetoacetate. In this case, the multivalent metal may include aluminum, iron, zinc, tin, titanium, antimony, magnesium or vanadium, and the like; and the photocrosslinking agent may include a multifunctional acrylate, and the like. One, two or more of the crosslinking agents may be used considering a kind of crosslinkable functional group included in the polymer.

[0076] A weight ratio of the multifunctional crosslinking agent in the pressure-sensitive adhesive layer may be controlled, for example, considering a desired peel strength.

[0077] The above-described pressure-sensitive adhesive layer may be formed, for example, by coating a coating solution obtained by mixing the acrylic polymer and multifunctional crosslinking agent as described above, and then inducing a crosslinking reaction of the polymer and multifunctional crosslinking agent under the proper conditions.

[0078] Also, the pressure-sensitive adhesive layer may further include an active energy ray-polymerizable compound in a polymerized state. As such, the active energy ray-polymerizable compound may mean a compound containing at least two functional groups, such as an acryloyl group or a methacryloyl group, which may take part in polymerization or cross-linking by irradiation with active energy rays.

[0079] As such, the pressure-sensitive adhesive layer may include a cross-linking structure including an acryl polymer cross-linked by the multifunctional cross-linking agent and a cross-linking structure including the active energy ray-polymerizable compound in a polymerized state at the same time.

[0080] For example, the above-described multifunctional acrylate may be used as the active energy ray-polymerizable compound. Also, the active energy ray-polymerizable compound may be a compound referred to as a photopolymerizable oligomer. Here, urethane acrylate, epoxy acrylate, polyester acrylate or polyether acrylate may be used as the active energy ray-polymerizable compound.

[0081] A weight ratio of the active energy ray-polymerizable compound in the pressure-sensitive adhesive layer may be adjusted in consideration of a desired peel strength.

[0082] The pressure-sensitive adhesive composition prepared by blending the acryl polymer, the multifunctional cross-linking agent and the active energy ray-polymerizable compound may be formed into a pressure-sensitive adhesive layer, for example, by inducing a cross-linking reaction of the acryl polymer and the multifunctional cross-linking agent and a polymerization reaction of the active energy ray-polymerizable compound under suitable conditions. The pressure-sensitive adhesive composition may include a polymerization initiator in consideration of the polymerization efficiency of the active energy ray-polymerizable compound. For example, a radical initiator that can induce a cross-linking or polymerization reaction of the active energy ray-polymerizable compound may be used as the polymerization initiator. For example, the radical initiator may include benzoin, benzoin methylether, benzoin ethylether, benzoin isopropylether, benzoin n-butylether, benzoin isobutylether, acetophenone, dimethylamino acetophenone, 2, 2-dimethoxy-2-phenylacetophenone, 2, 2-diethoxy-2-phenylacetophenone, 2-hydroxy-2-methyl-1-phenylpropane-1-one, 1-hydroxycyclohexylphenylketone, 2-methyl-1-[4-(methylthio) phenyl] -2-morpholino-propane-1-one, 4-(2-hydroxyethoxy) phenyl-2-(hydroxy-2-propyl) ketone, benzophenone, p-phenylbenzophenone, 4, 4'-diethylaminobenzophenone, dichlorobenzophenone, 2-methylantraquinone, 2-ethylantraquinone, 2-t-butylantraquinone, 2-aminoanthraquinone, 2-methylthioxanthone, 2-ethylthioxanthone, 2-chlorothioxanthone, 2, 4-dimethylthioxanthone, 2, 4-diethylthioxanthone, benzyldimethylketal, acetophenone dimethylketal, p-dimethylamino benzoic acid ester, oligo [2-hydroxy-2-methyl-1-[4-(1-methylvinyl) phenyl] propanone] and 2, 4, 6-trimethylbenzoyl-diphenyl-phosphineoxide, which may be used at a proper weight ratio.

[0083] The pressure-sensitive adhesive layer may further include at least one additive selected from the group consisting of a coupling agent, a tackifier, an epoxy resin, a UV stabilizer, an antioxidant, a toning agent, a reinforcing agent, a filling agent, an antifoaming agent, a surfactant, and a plasticizer within a range that does not affect desired effects.

[0084] A thickness of the pressure-sensitive adhesive layer may be properly selected according to an applied use, for example, a desired peel strength, an probability of realizing a 3D shape, a size of gap to be filled, and the like, but the present application is not specifically limited thereto.

[0085] The tape may further include a release sheet attached to the pressure-sensitive adhesive layer in order to protect the pressure-sensitive adhesive layer before using the tape.

[0086] Also, the present application is directed to providing a method of manufacturing a battery. The method according

to one exemplary embodiment may include contacting the tape with an electrolyte in a state in which an electrode assembly having the tape attached thereto is received in a can.

[0087] As shown in FIG. 1, the method may include forming a tape 102 having a 3D shape by contacting the substrate layer with an electrolyte so as to allow the substrate layer to deform, for example, swell, in a state in which the tape 101 is attached via the pressure-sensitive adhesive layer to the electrode assembly 104 having a gap formed therein.

[0088] The method may be performed, for example, by attaching the tape to an electrode assembly, receiving the electrode assembly inside a can, and injecting an electrolyte into the inside of the can.

[0089] According to one exemplary embodiment, the electrode assembly may be an electrode assembly for a secondary cell, for example, a lithium secondary cell.

[0090] The electrode assembly may include a positive electrode plate; a negative electrode plate; and a separator formed between the positive electrode plate and negative electrode plate, and the tape for fixing an electrode assembly may be attached onto the outer circumferential surface of the electrode assembly via the pressure-sensitive adhesive layer in the above-described method. The electrode assembly may be coiled in a jellyroll shape in some cases.

[0091] The positive electrode plate may include a positive electrode collector composed of a sheet metal with excellent conductivity, and the like; and a positive electrode active material layer that is coated on the surface of the positive electrode collector. In addition, an area that is not coated with the positive electrode active material may be formed on both ends of the positive electrode plate, and a positive electrode tab that protrudes to a predetermined length from an upper part or bottom part of the electrode assembly may be attached to the above-described area. The positive electrode tab may play a role in electrically connecting the electrode assembly with other parts of a battery, electronically.

[0092] In addition, the negative electrode plate may include a negative electrode collector composed of a conductive sheet metal, and the like; and a negative electrode active material layer that is coated on the surface of the negative electrode collector. In addition, an area that is not coated with the negative electrode active material may be formed on both ends of the negative electrode plate, like the positive electrode plate, and a negative electrode tab, which protrudes to a predetermined length from an upper part or bottom part of the electrode assembly and can electronically connect the electrode assembly and other parts of a battery, may be attached to the above-described area.

[0093] In addition, the electrode assembly may further include an insulation plate formed on an upper part and/or bottom part in order to prevent contact with a cap assembly or a cylindrical can.

[0094] Since the tape for fixing an electrode assembly includes a closing part in which an outermost end of the separator at the outer circumferential surface of the electrode assembly is positioned, the tape for fixing an electrode assembly may be attached to the electrode assembly to surround the outer circumferential surface of the electrode assembly. In addition, the tape for fixing an electrode assembly may be attached to cover at least 30% of the total area of the outer circumferential surface of the electrode assembly. In this case, an upper end part and bottom end part of the outer circumferential surface of the electrode assembly may be attached so that the electrode assembly can be exposed to external environments.

[0095] FIG. 3 is a schematic diagram showing the electrode assembly having the tape attached thereto. Here, a wound type of a cylindrical electrode assembly is shown in FIG. 3, but types of the electrode assembly to which the tape for fixing an electrode assembly is applied are not particularly limited.

[0096] Referring to FIG. 3, the electrode assembly 3 includes a positive electrode plate 31, a positive electrode tab 32, a negative electrode plate 33, a negative electrode tab 34 and a separator 35. Here, the tape 36 is attached to an outer surface of the assembly 3.

[0097] According to one exemplary embodiment shown in FIG. 3, the tape 36 for fixing an electrode assembly includes a finishing portion 37 in which the outermost end portions of the separator 35 are disposed at an outer circumferential surface of the electrode assembly. Thus, the tape may be attached to the separator 35 to surround the outer circumferential surface of the separator 35.

[0098] As shown in FIG. 3, the tape 36 for fixing an electrode assembly may be attached to a region other than the upper and lower end portions of the outer circumferential surface of the electrode assembly. The upper end portion may be a space through which an electrolyte permeates between the can and the electrode assembly 3, and the lower end portion may be a region in which the electrolyte injected into the bottom of the can comes in contact with the electrode assembly 3.

[0099] A kind of the can receiving the electrode assembly may include, for example, a cylindrical can, and the like, which are known in the art, but the present application is not specifically limited thereto.

[0100] In addition, a kind of the electrolyte solution, a electrolyte that can deform, for example, swell, the tape, may include an electrolyte known in the art according to a kind of a battery, but the present application is not specifically limited thereto. For example, when the battery is a lithium secondary battery, the electrolyte may include, for example, a water-insoluble organic solvent and a lithium salt. The above-described lithium salt may be dissolved in an organic solvent to serve as a source of lithium ions in a battery and may accelerate a movement of the lithium ions between a positive electrode and a negative electrode. An example of the lithium salt may be a lithium salt including one, two or more of LiPF_6 , LiBF_4 , LiSbF_6 , LiAsF_6 , LiCF_3SO_3 , $\text{Li}(\text{CF}_3\text{SO}_2)_3$, $\text{Li}(\text{CF}_3\text{SO}_2)_2\text{N}$, $\text{LiC}_4\text{F}_9\text{SO}_3$, LiClO_4 , LiAlO_4 , LiAlCl_4 ,

LiN(C_xF_{2x}+1SO₂) (C_yF_{2y}+1SO₂) (here, x and y are natural numbers), LiCl, Lil, lithium bisoxalate borate, and the like, as a supporting electrolytic salt. A concentration of the lithium salt in the electrolyte may be varied according to its application, and may be generally within the range of 0.1 M to 2.0 M. In addition, the organic solvent may serve as a medium that can move ions involved in an electrochemical reaction of a battery, and examples of the organic solvent may include one, two or more of benzene, toluene, fluorobenzene, 1, 2-difluorobenzene, 1, 3-difluorobenzene, 1, 4-difluorobenzene, 1, 2, 3-trifluorobenzene, 1, 2, 4-trifluorobenzene, chlorobenzene, 1, 2-dichlorobenzene, 1, 3-dichlorobenzene, 1, 4-dichlorobenzene, 1, 2, 3-trichlorobenzene, 1, 2, 4-trichlorobenzene, iodobenzene, 1, 2-diiodobenzene, 1, 3-diiodobenzene, 1, 4-diiodobenzene, 1, 2, 3-triiodobenzene, 1, 2, 4-triiodobenzene, fluorotoluene, 1, 2-difluorotoluene, 1, 3-difluorotoluene, 1, 4-difluorotoluene, 1, 2, 3-trifluorotoluene, 1, 2, 4-trifluorotoluene, chlorotoluene, 1, 2-dichlorotoluene, 1, 3-dichlorotoluene, 1, 4-dichlorotoluene, 1, 2, 3-trichlorotoluene, 1, 2, 4-trichlorotoluene, iodotoluene, 1, 2-diiodotoluene, 1, 3-diiodotoluene, 1, 4-diiodotoluene, 1, 2, 3-triiodotoluene, 1, 2, 4-triiodotoluene, R-CN (wherein R is a hydrocarbon radical with a linear, branched or circular structure having 2 to 50 carbon atoms, in which the hydrocarbon radical may include a double bond, an aromatic ring, or an ether bond, and the like), dimethylformamide, dimethylacetate, xylene, cyclohexane, tetrahydrofuran, 2-methyltetrahydrofuran, cyclohexanone, ethanol, isopropyl alcohol, dimethyl carbonate, ethylmethyl carbonate, diethyl carbonate, methylpropyl carbonate, propylene carbonate, methyl propionate, ethyl propionate, methyl acetate, ethyl acetate, propyl acetate, dimethoxyethane, 1, 3-dioxolane, diglyme, tetraglyme, ethylene carbonate, propylene carbonate, γ -butyrolactone, sulfolane, valerolactone, decanolide, or mevalolacton, but the present application is not limited thereto.

[0101] According to one exemplary embodiment, the electrolyte may be a carbonate-based electrolyte. According to one exemplary embodiment, the carbonate-based electrolyte may also be a liquid-phase electrolyte solution.

[0102] A pressure-sensitive adhesive layer, which has a predetermined peel strength with respect to a substrate layer with a deformation property, for example, an swelling property, as described above, is formed on the tape for fixing an electrode assembly. Accordingly, the tape may realize the 3D shape after the tape is subjected to the method, for example, in a state in which the tape is attached to an electrode assembly. As a result, the tape may effectively fill a gap between the internal wall of the electrode assembly and the can and fix the electrode assembly, thereby preventing movement or shaking.

[0103] In other words, the "3D shape" of the tape for fixing an electrode assembly may be formed through interaction of a deformation ability of a substrate layer of the tape for fixing an electrode assembly contacting an electrolyte and a peel strength of the pressure-sensitive adhesive layer, and may be a concept including any structure that can firmly fix an electrode assembly inside the can.

[0104] FIG 4 is a diagram of an exemplified battery manufactured by the above-described method, showing tapes for fixing an electrode assembly 51a and 51b forming a 3D shape by means of an electrolyte so that an electrode assembly 53 can be fixed in a can 52.

[0105] For example, as shown in an exemplified left diagram of FIG 4, the tape for fixing an electrode assembly 51a may be maintained in a flat shape when inserted into the can 52 after being attached to the assembly 53. However, after a predetermined amount of time after contacting the electrolyte injected into the can 52, as exemplarily shown in a right diagram of FIG 4, the tape for fixing an electrode assembly 53b may form a 3D shape, and thus it can be possible to fill a gap between the electrode assembly 53 and the can 52 and fix the electrode assembly 53.

BRIEF DESCRIPTION OF THE DRAWINGS

[0106] The above and other objects, features and advantages of the present application will become more apparent to those of ordinary skill in the art by describing in detail exemplary embodiments thereof with reference to the attached drawings, in which:

[0107] FIG 1 is a schematic diagram showing a process of forming the tape for fixing an electrode assembly into a 3D shape;

[0108] FIG 2 is a schematic diagram showing the tape for fixing an electrode assembly; and

[0109] FIG 3 is a schematic diagram showing a process of forming the tape for fixing an electrode assembly into a 3D shape in a process of manufacturing a battery.

[0110] FIG. 4 is a schematic diagram showing a process of manufacturing the battery according to one exemplary embodiment.

DETAILED DESCRIPTION OF EXEMPLARY EMBODIMENTS

[0111] Hereinafter, exemplary embodiments of the present application will be described in detail. However, the present application is not limited to the embodiments disclosed below, but can be implemented in various forms. The following embodiments are described in order to enable those of ordinary skill in the art to embody and practice the present application.

[0112] In the following Examples and Comparative Examples, physical properties of tapes for fixing an electrode assembly and batteries are evaluated, as follows.

[0113] **1. Measurement of Strain of Substrate layer in Longitudinal direction**

[0114] A substrate layer was cut to be 10 mm wide and 50 mm long to prepare a specimen. The prepared specimen was impregnated in a carbonate-based electrolyte, and then was maintained at room temperature for 1 day in a sealed state. Then, the specimen was removed from the electrolyte; a height of the specimen was measured; and then a strain of the substrate layer in a longitudinal direction was measured based on the following Equation A.

[0115]

Equation A

$$\text{Strain in Longitudinal direction} = (L_2 - L_1) / L_1 \times 100$$

[0116] In Equation A, L_1 is an initial length of the substrate layer in a longitudinal direction before the substrate layer is impregnated in an electrolyte, that is, 50 mm; and L_2 is a length of the substrate layer in a longitudinal direction after the substrate layer is impregnated in an electrolyte.

[0117] **2. Measurement of Peel strength of Tape for fixing an electrode assembly**

[0118] A tape for fixing an electrode assembly was cut to be 25 mm wide and 200 mm long to prepare a specimen. The specimen was attached via a pressure-sensitive adhesive layer to a glass plate using a 2kg rubber roller, and then stored at room temperature for 2 hours. Then, a peel strength was measured while a tape for fixing an electrode assembly was peeled with a peel rate of 5 mm/sec and a peel angle of 180° using a tensile tester.

[0119] **3. Evaluation of Ability of Tape for fixing an electrode assembly to Realize 3D shape**

[0120] The batteries manufactured in Examples and Comparative Examples were stored at room temperature for 1 day, and then were disassembled to remove electrode assemblies. Probability of realization of 3D shapes was evaluated by evaluating conditions of tapes for fixing an electrode assembly that were attached to the electrode assemblies according to the following criteria.

[0121] <Evaluation Criteria of Probability of realizing 3D shape>

[0122] ○: A 3D shape of a tape for fixing an electrode assembly is observed.

[0123] △: A 3D shape of a tape for fixing an electrode assembly is not observed.

[0124] ×: A 3D shape of a tape for fixing an electrode assembly is not observed and the tape is peeled from an electrode assembly.

[0125] **4. Evaluation of Ability of Tape for fixing an electrode assembly to Fill Gap (Ability to Prevent Movement of Electrode Assembly)**

[0126] An ability of the tape to fill a gap by may be measured using a method of evaluating a property of preventing a movement of an electrode assembly. For example, the above-described method includes a method of evaluating a residual vibration and a method of evaluating a residual impact. The method of evaluating the residual vibration is performed according to a vibration test of UN38.3 standard and it is judged that a terminal is disconnected by a movement when a power of a battery is not sensed after evaluation. For the way of evaluating the residual impact, a terminal is judged to be disconnected by a movement when a power of a battery is not sensed a predetermined time after a battery is added to an octagonal cylinder and then is spun. The abilities of the tapes to filling gaps, which were evaluated as described above, were evaluated according to the following criteria:

[0127] <Evaluation Criteria of Ability to Fill Gap>

[0128] ○: A power of a battery is measured after evaluations of a residual vibration and a residual impact.

[0129] △: A power of a battery is measured after evaluations of a residual vibration and a residual impact, but the resistivity is increased by 10% or more.

[0130] ×: A power of a battery is not measured after evaluations of a residual vibration and a residual impact.

[0131] **Preparative Example 1. Manufacture of Urethane-based Substrate layer**

[0132] A film having a thickness of approximately 40 μm was formed with a composition including butanediol polyol and methylene diphenyl diisocyanate with an equivalent ratio of approximately 1:1 of the hydroxyl group of the polyol and the isocyanate group of the diisocyanate, using T-die, and then cured to manufacture a substrate. A strain of the manufactured substrate in a longitudinal direction was approximately 100%.

[0133] **Preparative Example 2. Manufacture of Urethane Acrylic Substrate layer**

[0134] After mixing 40 parts by weight urethane acrylate and 70 parts by weight isobornyl acrylate (IBOA) as diluents, 0.5 parts by weight of a photoinitiator (Irgacure-184, 1-hydroxyl cyclohexyl phenylketone) was further added, mixed, and defoamed to prepare a composition. The prepared composition was coated on a polyester release film to have a thickness of approximately 40 μm using a bar coater. The polyester release film was covered on the coating layer in order to

prevent contact of oxygen and then the composition was cured by irradiation with light of the UV-A region at a radiation intensity of 800 mJ/cm² using a metal halide lamp to manufacture a substrate layer. A strain of the manufactured substrate layer in a longitudinal direction was approximately 43%.

[0135] Preparative Example 3: Manufacture of Epoxy Acrylic-based Substrate layer

After mixing 60 parts by weight epoxy acrylate, 38 parts by weight IBOA, and 2 parts by weight acrylic acid, 1.2 parts by weight of a photoinitiator (Irgacure-184, 1-hydroxyl cyclohexyl phenylketone) was further added, mixed, and defoamed to prepare a composition. The prepared composition was coated on a polyester release film to have a thickness of approximately 40 μm using a bar coater. The polyester release film was covered on the coating layer in order to prevent contact of oxygen and then the composition was cured by irradiation with light of the UV-A region at a radiation intensity of 800 mJ/cm² using a metal halide lamp to manufacture a substrate layer. A strain of the manufactured substrate layer in a longitudinal direction was approximately 11%.

[0137] Preparative Example 4. Manufacture of Cellulose-based Substrate layer

A raw material including a cellulose acetate propionate compound having a number average molecular weight (Mn) of 70, 000 as measured by GPC was molded as a substrate layer having a thickness of approximately 40 μm using T-die. A strain of the manufactured substrate layer in a longitudinal direction was approximately 20%.

[0139] Example 1

[0140] Manufacture of Tape of fixing an electrode assembly

A tape for fixing an electrode assembly was manufactured by forming a pressure-sensitive adhesive layer having a thickness of 15 μm and a peel strength of 1, 900 gf/25 mm with respect to a glass plate as an acrylic-based pressure-sensitive adhesive layer including an acrylic pressure-sensitive adhesive resin, which is crosslinked with an isocyanate crosslinking agent, on one surface of the urethane-based substrate layer (thickness of 40 μm) manufactured in Preparative Example 1.

[0142] Manufacture of Electrode Assembly and Battery

A tape for fixing an electrode assembly was attached to cover approximately 50% of the outer circumferential surface of a jelly roll-shaped electrode assembly (cross-sectional diameter: approximately 17.45 mm to 17.24 mm) in which the electrode assembly includes a negative electrode, a positive electrode and a separator, and then the electrode assembly was inserted into a cylindrical can (cross-sectional diameter: approximately 17.50 mm to 17.55 mm). Subsequently, a carbonate-based electrolyte was injected into the can, which was then sealed to complete a battery.

[0144] Examples 2 to 4 and Comparative Examples 1 and 2

Tapes for fixing an electrode assembly and batteries were manufactured in the same manner as in Example 1, except that substrate layers were changed as shown in the following Table 1, and the pressure-sensitive adhesive layer based on the same composites as in Example 1 was used; but peel strengths of the pressure-sensitive adhesive layers to a glass were changed as shown in the following Table 1 when the tapes for fixing an electrode assembly were manufactured.

[0146]

Table 1

		Examples				Comparative Examples	
		1	2	3	4	1	2
Substrate layer	Kinds	Preparative Example 1	Preparative Example 2	Preparative Example 3	Preparative Example 4	PP	PET
	Strain	100	43	11	20	0	0
Pressure-sensitive adhesive layer	Compositions	Acrylic	Acrylic	Acrylic	Acrylic	Acrylic	Acrylic
	Peel strength	1900	900	150	2000	1500	60
Strain: Strain of substrate layer in longitudinal direction (unit: %) Peel strength: Peel strength with respect to glass plate (unit: gf/25 mm) PP: Polypropylene substrate layer having strain of 0% in longitudinal direction (thickness: 40 μm) PET: Polyethyleneterephthalate substrate layer having strain of 0% in longitudinal direction (thickness: 25 μm)							

[0147] Physical Properties measured for the above Examples and Comparative Examples are summarized and listed in the following Table 2.

[0148]

Table 2

	Examples				Comparative Examples	
	1	2	3	4	1	2
Probability of realization of 3D shape	○	○	○	○	Δ	Δ
Ability to Fill Gap (Ability to Prevent Movement)	○	○	○	○	×	×

[0149] The tape for fixing an electrode assembly can, for example, effectively fix an electrode assembly in a can by realizing a 3D shape by means of an electrolyte. Thus, the tape can be useful in preventing the electrode assembly from moving and rotating inside the can by external vibration or impact and also preventing damage of welded regions of a tab or disconnection of inner circuits.

Claims

1. A tape for fixing an electrode assembly comprising:

a substrate layer deforming in a longitudinal direction when coming in contact with an electrolyte; and
a pressure-sensitive adhesive layer formed on one surface of the substrate layer in a direction parallel to the longitudinal direction of the substrate layer.

2. The tape of claim 1, wherein a three-dimensional (3D) structure having a height of 0.001 mm to 2.0 mm is formed in a direction vertical to the longitudinal direction when coming in contact with the electrolyte.

3. The tape of claim 1, wherein the substrate layer has a strain of 10% or more in the longitudinal direction according to the following Equation 1:

Equation 1

Strain in longitudinal direction = $(L_2 - L_1) / L_1 \times 100$

wherein L_1 is an initial length of the substrate layer before the substrate layer comes in contact with the electrolyte; and

L_2 is a length of the substrate layer, which is measured after the substrate layer comes in contact with the electrolyte at room temperature or 60 °C for 24 hours.

4. The tape of claim 1, wherein the substrate layer includes a urethane bond, an ester bond or an ether bond, or includes a cellulose ester compound.

5. The tape of claim 1, wherein the substrate layer is a cast layer of a composition including an active energy ray-polymerizable acrylate compound and a radical-polymerizable diluent.

6. The tape of claim 5, wherein the active energy ray-polymerizable acrylate compound is urethane acrylate, epoxy acrylate, polyester acrylate or polyether acrylate.

7. The tape of claim 5, wherein the radical-polymerizable diluent comprises at least one selected from the group consisting of an alkyl (meth)acrylate; a (meth)acrylate having an alkoxy group; a (meth)acrylate having an alicyclic group; a (meth)acrylate having an aromatic group; a (meth)acrylate having a heterocyclic group; and a multifunctional acrylate.

8. The tape of claim 1, wherein the substrate layer comprises thermoplastic polyurethane.

9. The tape of claim 1, wherein the substrate layer is a cast layer of a curable urethane composition including polyol and isocyanate compounds.

10. The tape of claim 1, wherein the substrate layer comprises a cellulose acetate resin or a cellulose alkylate resin.
11. The tape of claim 1, wherein the pressure-sensitive adhesive layer has a peel strength at room temperature of 100 gf/25 mm or more, as measured at a peel angle of 180° and a peel rate of 5 mm/sec with respect to an electrode assembly or glass plate.
12. The tape of claim 1, wherein the pressure-sensitive adhesive layer includes an acryl pressure-sensitive adhesive, a urethane pressure-sensitive adhesive, an epoxy pressure-sensitive adhesive, a silicon pressure-sensitive adhesive or a rubber pressure-sensitive adhesive.
13. The tape of claim 1, wherein the electrolyte is a carbonate-based electrolyte solution.
14. A method of manufacturing a battery, comprising:
- contacting the tape of claim 1 with an electrolyte in a state in which an electrode assembly having the tape attached thereto is received in a can.
15. The method of claim 14, wherein the electrolyte is a carbonate-based electrolyte solution.

Fig. 1.

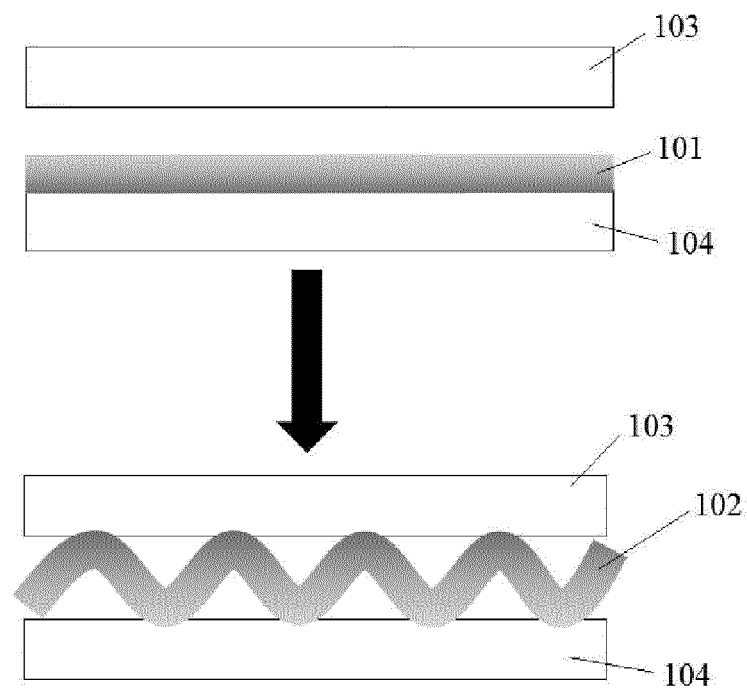


Fig. 2.

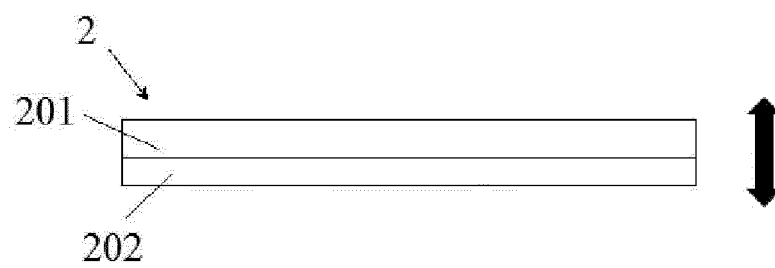


Fig. 3.

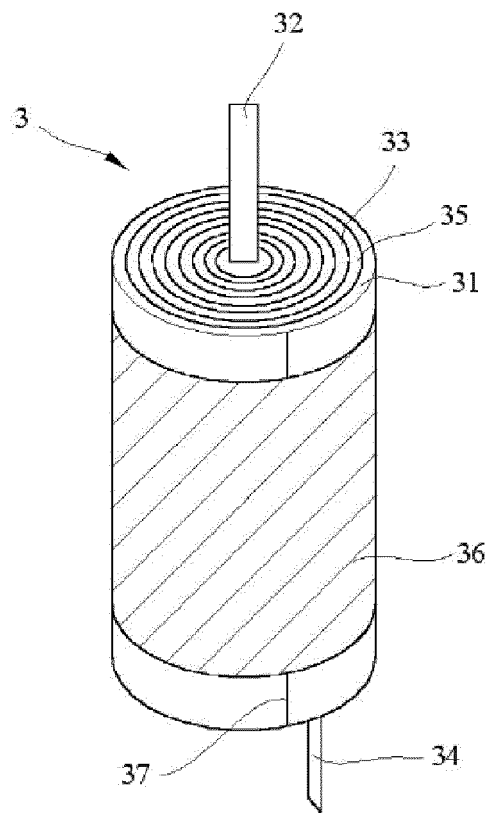
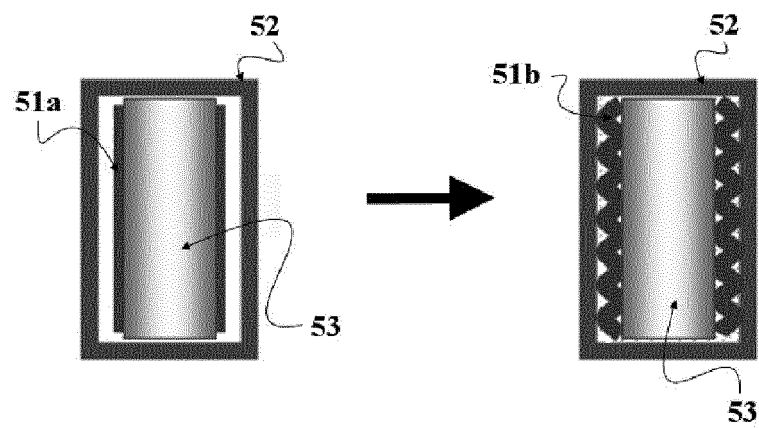


Fig. 4.



REFERENCES CITED IN THE DESCRIPTION

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